

Date: Wednesday, 27/09/2006 3:15:00 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001. Dart Helicopters Services	Drawing Name : TUBE
Job Number : 28750	
Estimate Number : 12303	
P.O. Number : NIA	Part Number : D34673
This Issue : 27/09/2006 S.O. No. : NIA	Drawing Number : D3467 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28585	Material : NIA
Written By : _____	Due Date : 04/10/2006 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : est rev. A 06.04.20 new issue EC Est Rev:B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
	Comment: Qty.: 0.1985 sf(s)/Unit Total: 0.7938 sf(s) 304/316 0.018 SHEET batch: M102376 MM 06/10/16	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET Cut as per Dwg D3467 Dwg Rev: B MM 06/10/16 (4)	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE MM 06/10/16 (4)	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK MM 06/10/16 (4)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Roll as per dwg D3467 MF 06/10/27 2- Spot weld as per dwg D3467 & QSI004 MF 06/10/27 3-Form bead as per dwg D3467 MSB 06/10/27 (4) 4- Debur MF 06/10/23 (4)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 06/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/09/2006 3:15:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 28750

Part Number: D34673

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

06-11-07 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST439*

06-11-08 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/08

Job Completion



U 06.11.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

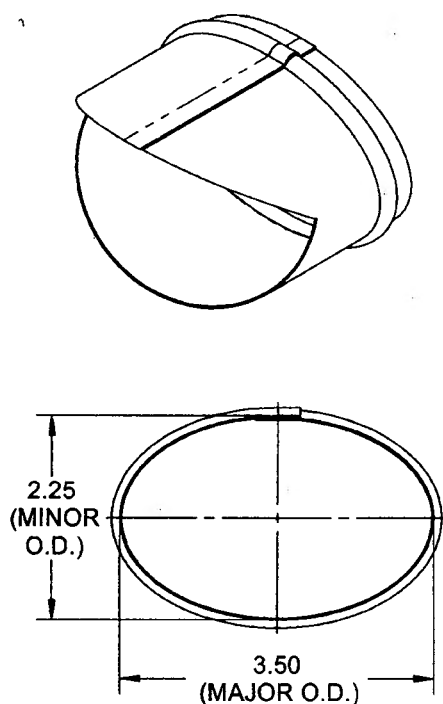
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

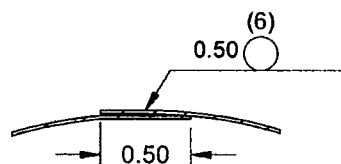


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3467	REV. B SHEET 7 OF 15
DATE 06.05.15	TITLE SHROUD ASSEMBLY SCALE 1:2		

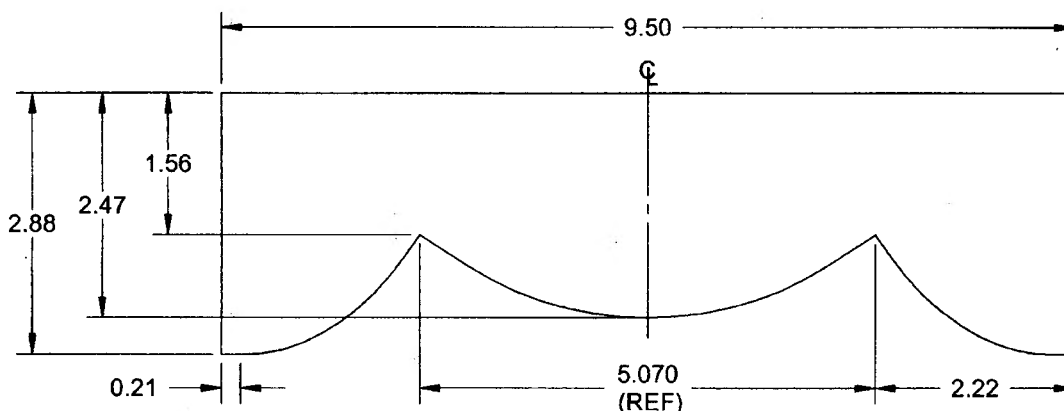
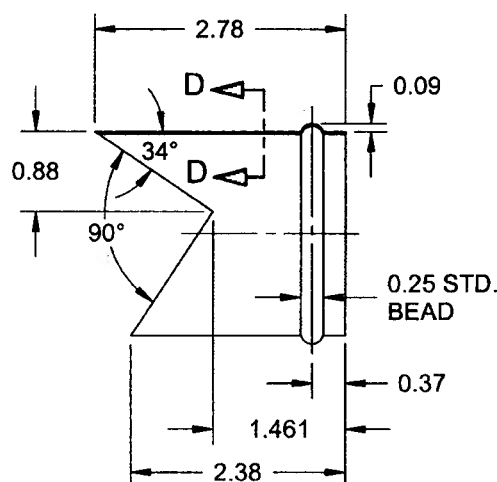
RELEASED
06.05.15



D3467-3 TUBE DETAIL



SECTION D-D
SCALE 1:1



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 1

EMPLOYEE: Melanie Fauteux

PART NUMBER: D 3467-3

JOB NUMBER: 28750

MATERIAL TYPE: 304/316 ~~201~~

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☒

Group 2: Iron; nickel; cobalt

☐

Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 06/10/27

QUALIFIER: Sylvie Bouchard